

Tungaloy

Member IMC Group

Keeping the Customer First

Tungaloy Report No. 386-E

ISO TOOL™

MILLLINE Super high feed cutter

DOFEEDMINI

NEW!

Highly efficient milling tools for mid to small range machines



DOFEEDMINI

- The next generation of super high feed milling cutters

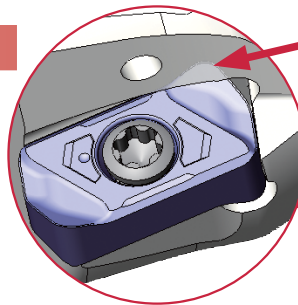
Highly efficient milling tools for mid to small range machines



- ☐ Suitable for high feed milling on small and mid size machines with remarkable anti-chatter characteristics. Exceptional machining efficiency!
- ☐ Economical insert with 4 cutting edges!

Features

Excellent chip evacuation with air hole



Protection for unused edge of insert



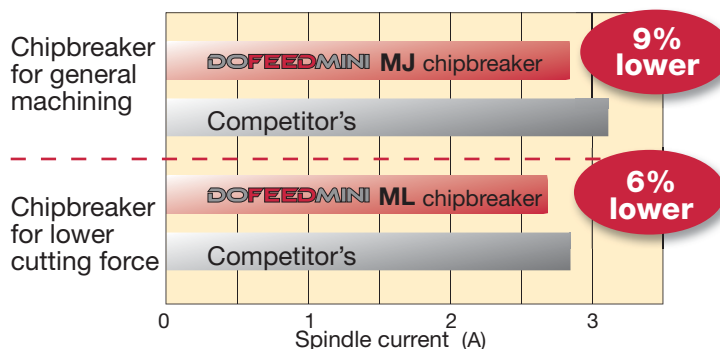
Tool ϕ	No. of inserts		Efficiency machining Comparison with competitor
	DOFEEDMINI	Competitor	
$\phi 16$	2	2	1.0 times
$\phi 20$	4	3	1.3 times
$\phi 25$	5	4	1.3 times
$\phi 30$	5	4	1.3 times
$\phi 32$	6	5	1.2 times

High density for efficient machining

Provides excellent performance on small machines due to the low cutting forces.

Cutting Performance

Comparison of cutting load

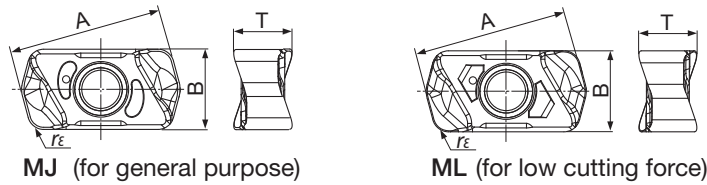


Cutter : EXN03R025M25.0-05 ($\phi 25$)
 Insert : LNMU0303ZER-MJ / ML
 Grade : AH725
 Work material : Carbon steels (S55C / C55E)
 Cutting speed : $V_c = 250$ m/min
 Feed : $f_z = 0.5$ mm/t (1 insert)
 Depth of cut : $a_p = 0.5$ mm
 Width of cut : $a_e = 25$ mm (Grooving)
 Coolant : Dry
 Machine : Vertical machining center BT40

Results: Spindle current of DoFeedMini is lower than competitor.

► **Good for low rigidity machine!**

Insert Specification

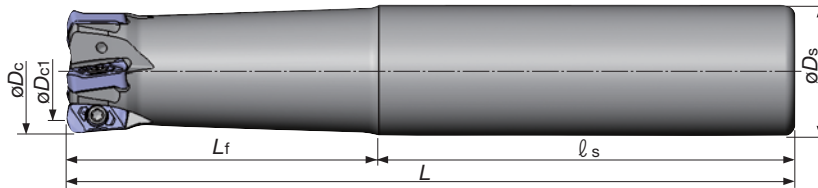


MJ (for general purpose)

ML (for low cutting force)

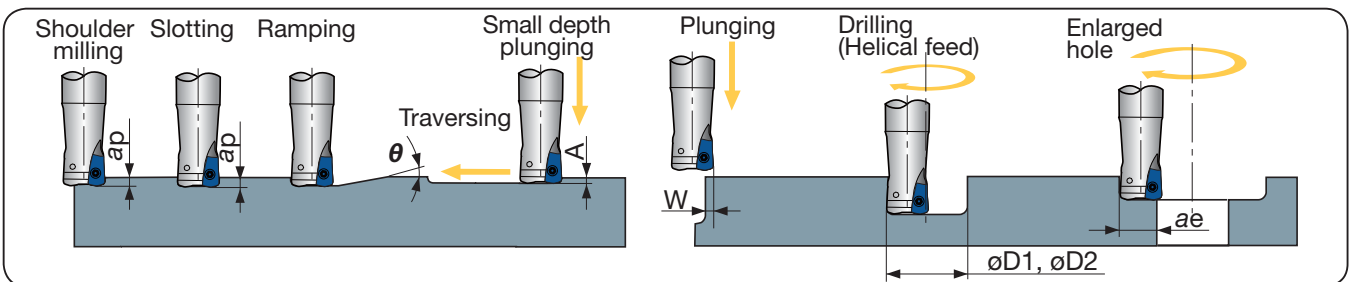
Cat. No.	Accuracy	Honing	Grades		Dimensions (mm)			
			AH725	AH130	A	B	T	r_{ϵ}
LNMU0303ZER-MJ	M	with	●	●	11.59	6.0	4.29	1.2
LNMU0303ZER-ML	M	with	●	●				

Cutter Specification



Type	Cat. No.	Stock	No. of Inserts	Dimensions (mm)						Weight (kg)	Air hole	Replacement Parts	
				ϕD_c	ϕD_s	ϕD_{c1}	L	L_f	l_s			Clamping Screw	Wrench
Standard	EXN03R016M16.0-02	●	2	16	16	9.5	100	30	70	0.05	with	CSPB-2.5	IP-8D
	EXN03R018M16.0-02	●	2	18	16	11.5	100	30	70	0.05			
	EXN03R020M20.0-04	●	4	20	20	13.5	130	50	80	0.10			
	EXN03R022M20.0-04	●	4	22	20	15.5	130	50	80	0.10			
	EXN03R025M25.0-05	●	5	25	25	18.5	140	60	80	0.18			
	EXN03R028M25.0-05	●	5	28	25	21.5	140	60	80	0.18			
	EXN03R030M32.0-05	●	5	30	32	23.5	150	70	80	0.31			
	EXN03R032M32.0-06	●	6	32	32	25.5	150	70	80	0.31			
Long	EXN03R016M16.0-02L	●	2	16	16	9.5	150	50	100	0.08			
	EXN03R018M16.0-02L	●	2	18	16	11.5	150	25	125	0.08			
	EXN03R020M20.0-03L	●	3	20	20	13.5	160	80	80	0.13			
	EXN03R022M20.0-03L	●	3	22	20	15.5	160	30	130	0.13			
	EXN03R025M25.0-04L	●	4	25	25	18.5	180	100	80	0.23			
	EXN03R028M25.0-04L	●	4	28	25	21.5	180	35	145	0.23			
	EXN03R030M32.0-04L	●	4	30	32	23.5	200	120	80	0.41			
	EXN03R032M32.0-05L	●	5	32	32	25.5	200	120	80	0.41			

Applications



Cat. No.	Tool ϕ ϕD_c (mm)	Max. depth of cut a_p (mm)	Max. ramping angle θ	Max. plunging depth A (mm)	Max. cutting width in plunging W (mm)	Min. machinable hole ϕ $\phi D1$ (mm)	Max. machinable hole ϕ $\phi D2$ (mm)	Max. cutting width in enlarged hole a_e (mm)
EXN03R016M16.0-□□□	$\phi 16$	1	2.1°	0.3	3.5	22	30	12.5
EXN03R018M16.0-□□□	$\phi 18$	1	1.7°	0.3	3.5	26	34	14.5
EXN03R020M20.0-□□□	$\phi 20$	1	1.4°	0.3	3.5	30	38	16.5
EXN03R022M20.0-□□□	$\phi 22$	1	1.2°	0.3	3.5	34	42	18.5
EXN03R025M25.0-□□□	$\phi 25$	1	1.0°	0.3	3.5	40	48	21.5
EXN03R028M25.0-□□□	$\phi 28$	1	0.8°	0.3	3.5	46	54	24.5
EXN03R030M32.0-□□□	$\phi 30$	1	0.7°	0.3	3.5	50	58	26.5
EXN03R032M32.0-□□□	$\phi 32$	1	0.7°	0.3	3.5	54	62	28.5

Standard cutting conditions

Work material	Hardness	Priority	Grades	Chip-breaker	Cutting Speed Vc (m/min)	Feed per tooth: fz (mm/t)			
						Tool- ϕ : $\phi 16 \sim 22$	Tool- ϕ : $\phi 25 \sim 32$	Plunging depth	
Carbon steels (S45C, S55C etc.) (C45E, C55E etc.)	~ 300HB	First choice	AH725	MJ	100 - 200 - 300	0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5	0.1	
		for low cutting force	AH725	ML		0.5 - 0.6 - 0.7	0.5 - 0.8 - 1.0		
		for impact resistance	AH130	MJ		0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5		
Alloy steels (SCM440, SCr415 etc.) (42CrMo4, 17Cr3 etc.)	~ 300HB	First choice	AH725	MJ	100 - 150 - 200	0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5	0.1	
		for low cutting force	AH725	ML		0.5 - 0.6 - 0.7	0.5 - 0.8 - 1.0		
		for impact resistance	AH130	MJ		0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5		
Prehardened steels (NAK80, PX5 etc.)	30 ~ 40HRC	-	AH725	MJ	100 - 150 - 200	0.5 - 0.6 - 0.7	0.5 - 0.8 - 1.0	0.1	
Stainless steels (SUS304, SUS316 etc.) (X5CrNi18-10, X5CrNiMo17-12-2 etc.)	~ 200HB	First choice	AH130	ML	100 - 120 - 150	0.3 - 0.4 - 0.5	0.3 - 0.5 - 0.7	0.08	
		for impact resistance	AH130	MJ		0.3 - 0.5 - 0.8	0.3 - 0.6 - 0.8		
Grey cast irons (FC250, FC300 / GG25, GG30 etc.) Ductile cast irons (FCD400 / GGG40 etc.)	150 ~ 250HB	-	AH725	MJ	100 - 200 - 300	0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5	0.1	
Titanium alloy (Ti-6Al-4V etc.)	~ 40HRC	-	AH725	ML	30 - 40 - 60	0.3 - 0.4 - 0.5	0.3 - 0.5 - 0.7	0.08	
Hardened steels	(SKD61 etc.) (X40CrMoV5-1 etc.)	40 ~ 50HRC	-	AH725	MJ	80 - 100 - 130	0.1 - 0.15 - 0.2	0.1 - 0.2 - 0.3	0.05
	(SKD11 etc.)	50 ~ 60HRC				50 - 60 - 70	0.03 - 0.04 - 0.05	0.03 - 0.05 - 0.07	0.03

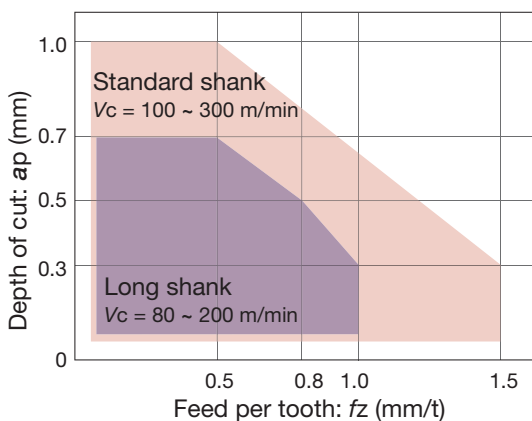
- When chips stay in the cutting zone during slotting or pocketing, use air to remove chips from the work area.
- Tool overhang length must be as short as possible to avoid chatter. When the tool overhang length is long, decrease the number of revolutions and feed.

- Cutting conditions are generally limited by the rigidity and power of the machine and the rigidity of the workpiece. When setting the conditions, start from half of the values of the standard cutting conditions and then increase the value gradually while making sure the machine is running normally.

Cautionary points in use

The usage of a standard & long shank

When using a long shank, please lower the cutting condition (Vc, fz, ap) to 70% of the standard shank.



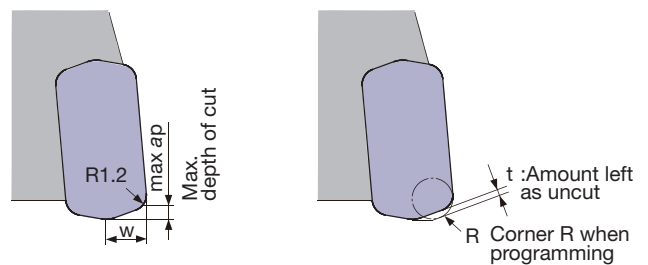
Tool- ϕ : $\phi 16 \sim 32$
 Work material: Carbon steels
 S55C / C55E (200HB)

L/D ratio of overhang

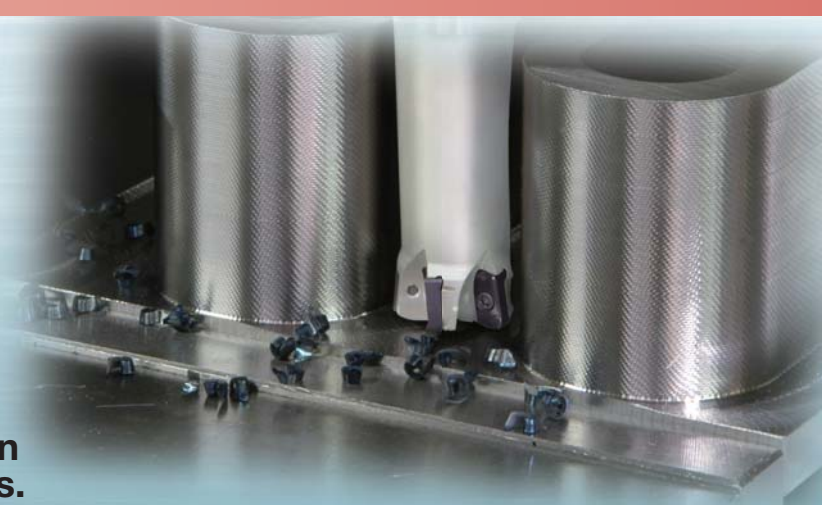
Standard shank: L/D ≤ 3
 Long shank: L/D = 4

Tool geometry on programming

When programming for CAD/CAM, the tool should be assumed to be a radius cutter as shown in the below table. In this case, the amount left as uncut (t) is shown in the below table.



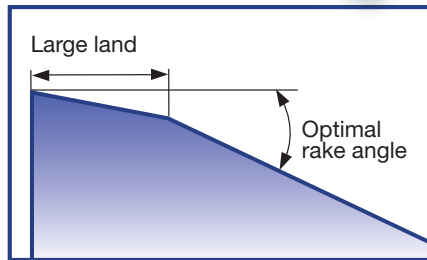
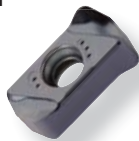
Max. depth of cut max ap (mm)	W (mm)	Amount left as uncut t (mm)	Corner R when programming
1.0	3.0	0.6	R 1.0
		0.5	R 1.5



DoFeedMini is one of the best tools for roughing operations on carbon and pre-hardened steels. It is ideal for highly efficient milling of titanium, as used in the aerospace industry.

Chipbreaker

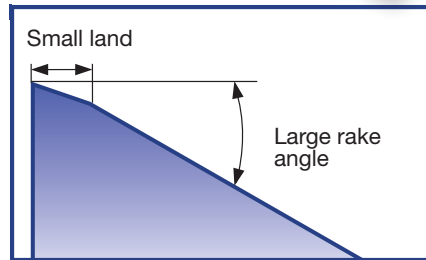
MJ Chipbreaker
(general purpose)



P Steel
K Cast iron
H Hard materials

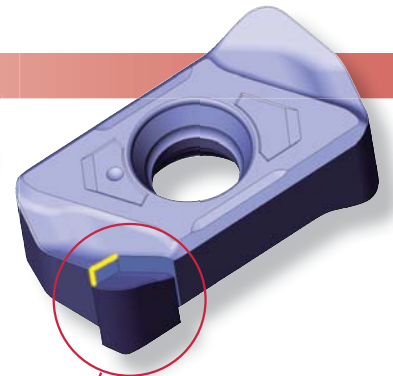
- Excellent combination of sharpness and strength
- Recommended for steel and cast iron machining

ML Chipbreaker
(lower cutting force)



M Stainless
S Super alloy

- Good sharpness
- Suitable for stainless steel and titanium
- Reduced chattering

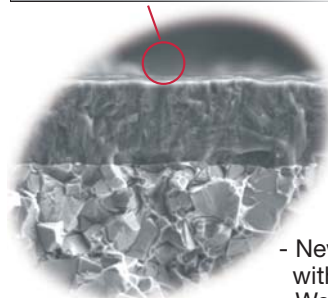


Grades

Special surface technology

PREMIUMTEC

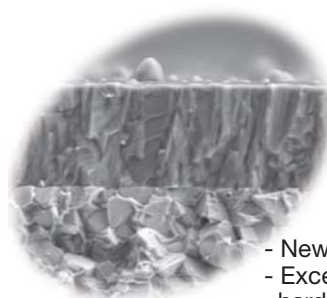
TUNGALOY



AH725

P Steel
K Cast iron
S Super alloy
H Hard materials

- Newly developed coating layer with a unique substrate
- Well balanced wear and chipping resistance
- Suitable for steels and cast irons



AH130

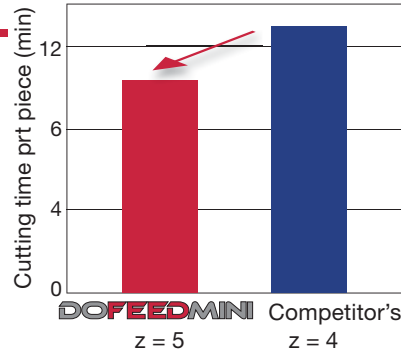
M Stainless
P Steel

- Newly developed substrate
- Excellent balanced between hardness and toughness
- Suitable for stainless steels

Practical examples

Pocket milling of die & mold

Cutter : EXN03R025M25.0-05 ($\phi 25$ mm, $z = 5$)
 Insert : LNMU0303ZER-MJ
 Grade : AH725
 Work material : S55C (200HB) / C55E
 Cutting speed : $V_c = 250$ m/min
 Feed : $f_z = 1.0$ mm/t
 Depth of cut : $a_p = 0.5$ mm
 Width of cut : $a_e = 15 \sim 25$ mm
 Coolant : Dry (air)
 Machine : Vertical machining center BT40

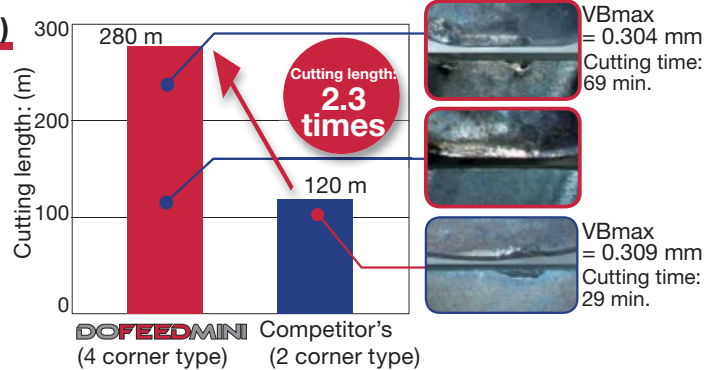


Results: High density of close pitch cutter delivers long tool life when combined with PremiumTec

20% reduction of machining time, Tool life is Doubled!

Machining of prehardened steels (40HRC)

Cutter : EXN03R025M25.0-05 ($\phi 25$ mm, $z = 5$)
 Insert : LNMU0303ZER-MJ
 Grade : AH725
 Work material : Prehardened steels (40HRC)
 Cutting speed : $V_c = 100$ m/min
 Feed : $f_z = 0.8$ mm/t
 Depth of cut : $a_p = 0.5$ mm
 Width of cut : $a_e = 18$ mm
 Coolant : Dry (air)
 Machine : Vertical machining center BT40



Results: 2.3 time improvement of cutting time

Saving 75% of tool cost!



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